

Work Order ID 141876

141876

Page 1

Thursday, February 18, 2016 1:29:22 PM

Item ID: D4365-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bar

Start Date: 2/18/2016 Start Qty: 16.00

16

Cust Item ID:

Required Date: 2/25/2016 Req'd Qty: 16.00

16

Customer:

Reference:

Approvals: Process Plan: *MCS*

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date: **FEB 18 2016**

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4365

A

0.00

100

Cold Saw

Memo

0.00

Hyd Mech

Cut blanks at 45.0"

****EXTRA MAT'L WILL BE TRIM OF AT ASSY****

110

0.00

110

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Mill as per folio F & dwg,

FOLIO REV: AA

DWG REV: A

2-Deburr as required

16

2/16-2-23

16

2/16-2-24

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval																																																									
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : ☐			
Misidentified ☐	Past Due ☐																																																																

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Plan
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Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.00

Quality Control

16

0

SL16-2-24

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

16

0

DAS
14
9-89

16/02/25

140

Identify as per dwg & Stock Location: w/A07

0.00

140

Packaging

Memo

0.00

Packaging

16

EL 16-2-25

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.00

Quality Control

ML5

FEB 25 2016

SA 20160225

Picklist Print

Thursday, February 18, 2016 1:29:28 PM

Page 1

Work Order ID: 141876

141876

Parent Item: D4365-1

D4365-1

Parent Item Name: Bar

Start Date: 2/18/2016

Required Date: 2/25/2016

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP REV:A 11.04.12 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304B0.250x0.500

Purchased

No

f

1,295.210

61.05263

M304B0 250x0 500

**

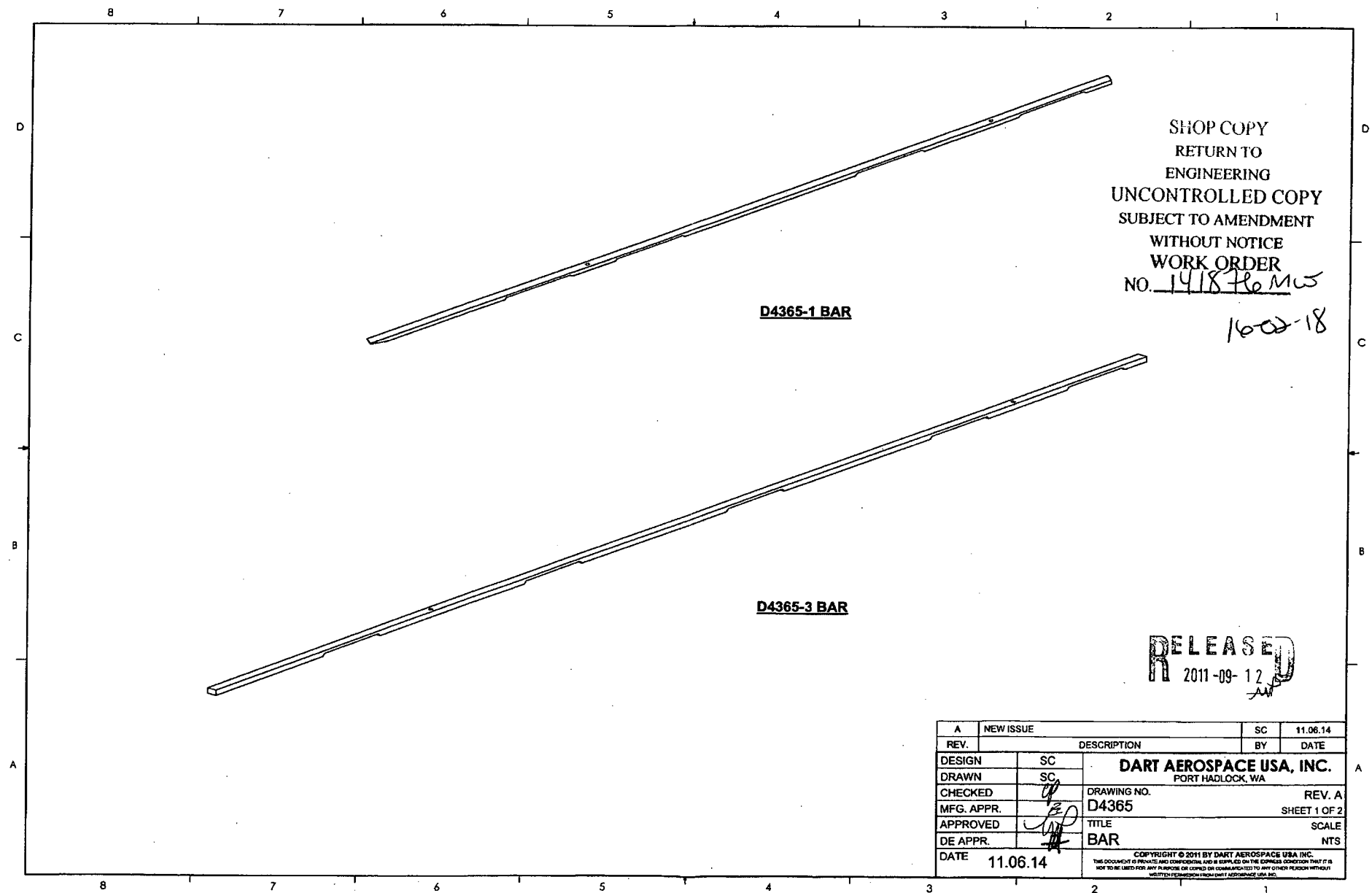
SL 16-2-23

304 BAR .250 x .500

Location	Loc Qty	Loc Code
MAT	258.909	
133276	10.979	
m133175	7.93	
m134172	240	
MAT009	532.3013	
m129366	18.967	
m131748	20.949	
m132332	48.5333	
m133121	12	
m133417	132.685	* 13.8
m133526	23.167	
m133596	96	
m134099	180	
WA002	504	
m133923	504	

FIRST ARTICLE INSPECTION CHECKLIST

Measured by: <u>SL</u>		Audited by: <u>14</u> <u>8-89</u>		Preliminary Approval:	
Date: <u>16-2-24</u>		Date: <u>16/02/25</u>		Date:	
Rev	Date	Change	Revised by		Approved
A	12.07.31	New Issue	KJ <u>SL</u>		<u>SL</u>



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 1418-16 MWS

1602-18

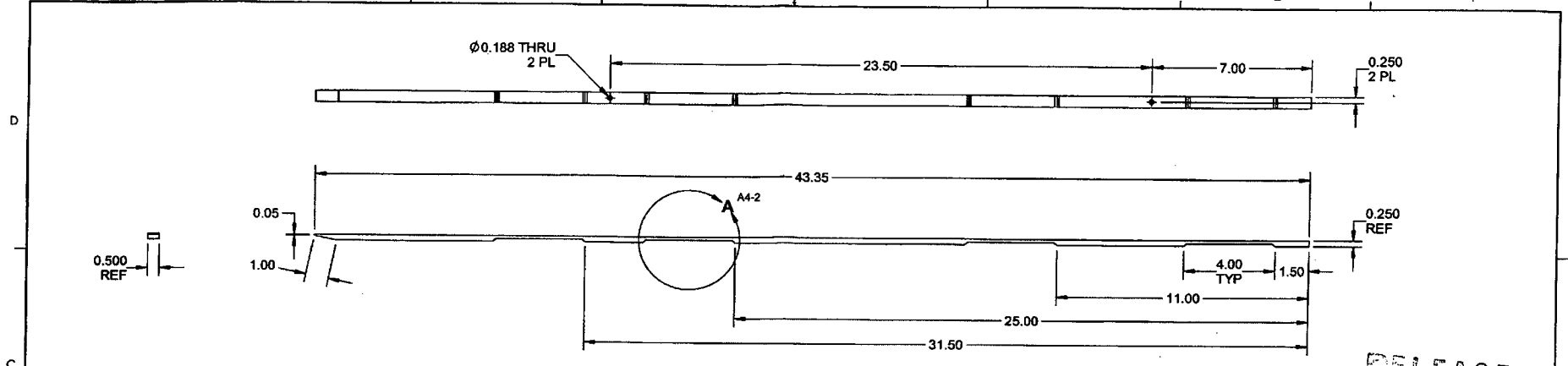
D4365-1 BAR

D4365-3 BAR

RELEASED
2011-09-12
AM

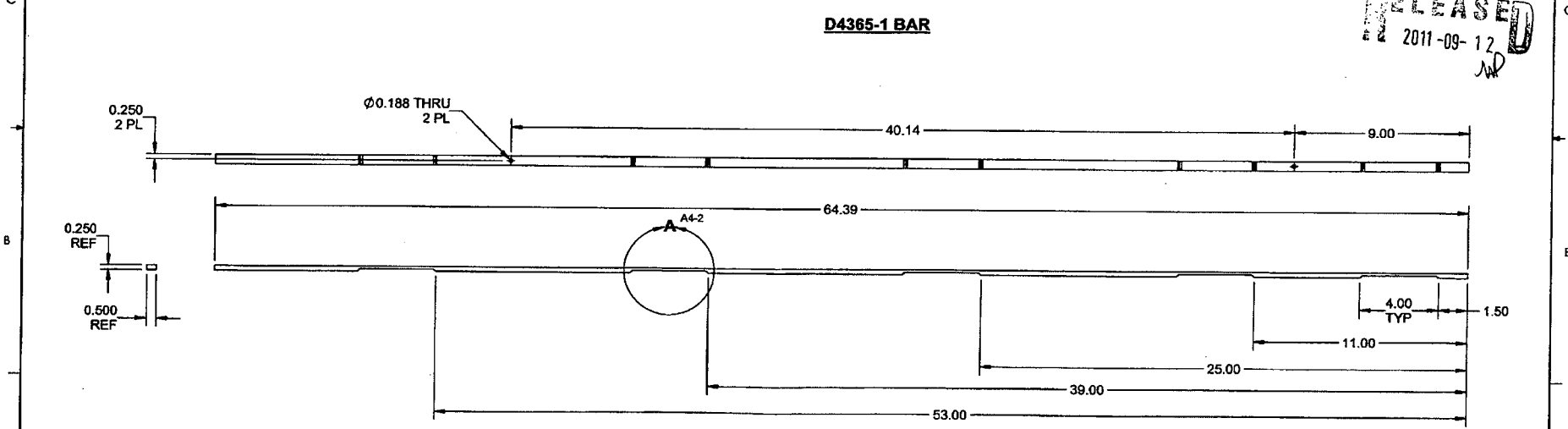
A	NEW ISSUE	SC	11.06.14
REV.	DESCRIPTION	BY	DATE
DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED	SC	DRAWING NO.	REV. A
MFG. APPR.	SC	D4365	SHEET 1 OF 2
APPROVED	SC	TITLE	SCALE
DE APPR.	SC	BAR	NTS
DATE	11.06.14	COPYRIGHT © 2011 BY DART AEROSPACE USA, INC.	
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8 7 6 5 4 3 2 1



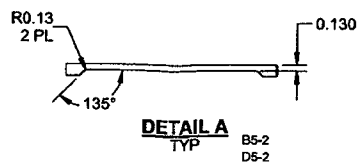
D4365-1 BAR

RELEASED
2011-09-12
AD



D4365-3 BAR

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR. 0.250 THICK X 0.500 WIDE
PER ASTM A276 OR ASTM A240
REF. DART SPEC. M304B0.250X00.500
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: D4365-1 = 1.28 lbs
D4365-3 = 1.98 lbs



DESIGN	SC	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	SC		
CHECKED	UP	DRAWING NO.	REV. A
MFG. APPR.	BE	D4365	SHEET 2 OF 2
APPROVED	MA	TITLE	SCALE
DE APPR.	MA	BAR	NTS
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8 7 6 5 4 3 2 1